

# Work Order ID 57248

March 31, 2010 10:03:17 AM



Page 1

Item ID: D5955

Accept

Revision ID:

Item Name: Saddle, 205

Start Date: 31/03/2010 Start Qty: 4.00

Required Date: 09/04/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-3-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D5955

Rev B

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

1-Machine as per folio D5955, Ensure Batch Number is entered  
Keyway 3-Debur & Tumble

B.A 10/04/07

4

Ø

110



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

Memo

0.00

B.A 10/04/07

4

Ø

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

MW  
10/04/07

4

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57248

March 31, 2010 10:03:17 AM



Page 2

Item ID: D5955

Revision ID:

Item Name: Saddle, 205

Start Date: 31/03/2010 Start Qty: 4.00

Required Date: 09/04/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

=> 4 10/04/08

x4

Ø

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

=> 4 10/04/08

x4

Ø

Memo

START TIME:

12:15pm FINISH TIME:

11:45am

OVEN TEMPERATURE:

320°F

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

BK 10-4-8.

④

Ø

Memo



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

**Work Order ID 57248**

March 31, 2010 10:03:17 AM



Page 3

Item ID: D5955

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, 205

Start Date: 31/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 430

0.00

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/10 (4)

10/04/10

MF

10-4-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

March 31, 2010 10:03:21 AM

Page 1

Work Order ID: 57248

Parent Item: D5955

Parent Item Name: Saddle, 205

Comments: IPP Rev:E Re-Format 05-11-29 JLM  
IPP Rev:F ecn826 06.12.06 cc

Start Date: 31/03/2010

Required Date: 09/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-013		Manufactured	No			100	Each	28.0000	4.0000			
Saddle Billet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT47	28	
46413	28	

4.0

H.A 10/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Outer Aft Saddle		<b>Part Number:</b> D5955	
<b>Inspection Dwg:</b> D5955	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.441	0.441	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.321	0.321	0.321	0.321		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.321	0.321	0.321	0.321		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.499	0.499	0.499	0.499		
N	1.865	1.885		1.880	1.885	1.880	1.881		
O	7.990	8.010		8.001	8.001	8.001	8.001		
P	2.240	2.260		2.256	2.257	2.258	2.258		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.763	0.763	0.763	0.763		
S	0.490	0.510		0.500	0.498	0.497	0.500		
T	1.625	1.645		1.632	1.635	1.635	1.636		
U	2.000	2.020		2.005	2.006	2.007	2.007		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: H.A.  
Date: 10/04/07

Audited by: MU  
Date: 10/04/07

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

W/O:		WORK ORDER CHANGES					
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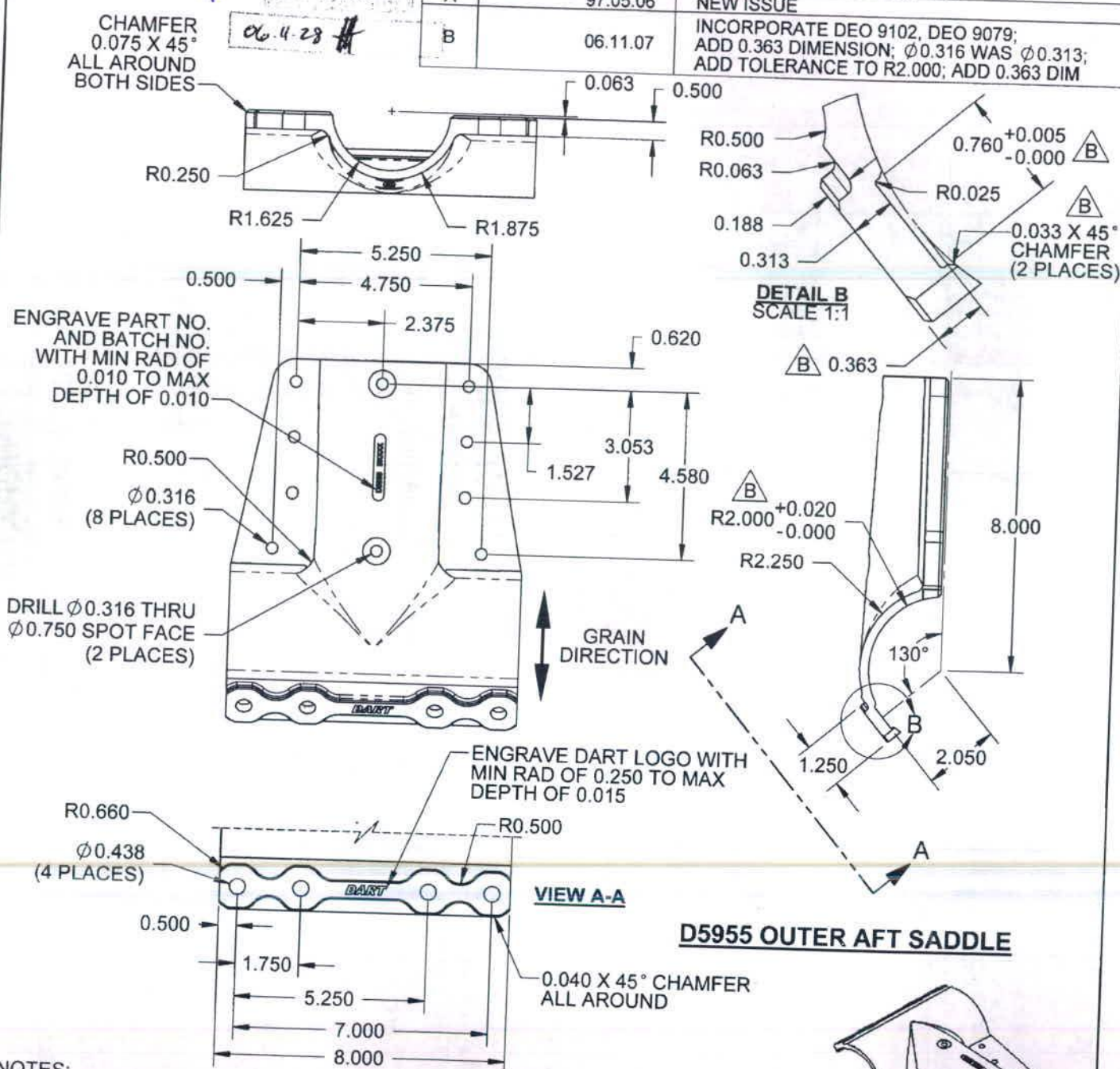
SHOP COPY  
RETURN TO  
DART  
SUBJECT TO

WITHOUT NOTICE  
WORK ORDER

NO

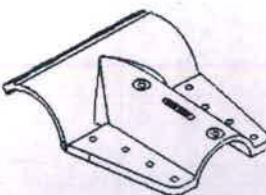
57248 0410331

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D5955	REV. B
DATE 06.11.07	TITLE OUTER AFT SADDLE		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	
		SHEET 1 OF 1	SCALE 1:4



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12 (MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



ISOMETRIC VIEW  
SCALE 1:8

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